

Thursday, December 15, 2016 1:34:03 PM

154600

Ship 6 JAN

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Hat Bin-Ivory

Start Date: 12/12/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/15/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** DEC 15 2016 **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D3824 Rev C

100

0.00

100

HandThermo

Memo

0.03

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DAS
07
9-89

16/12/20

105

0.00

105

HandThermo

Dry material

0.00

Hand Finishing Thermoforming

Memo

Dry Sheet as per QSI022 KYDEX
Temp: 150 deg. F

Time IN: 5:00 PM

Time IN. 6:00 AM

Time OUT: _____

DEC 20 2016

Per.....

DAS
07
9-89

16/12/20

154600

Thursday, December 15, 2016 1:34:03 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

1

Cust Item ID:

1

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

154600

Thursday, December 15, 2016 1:34:03 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

1

Start Date: 12/12/2016 **Start Qty:** 1.00

Required Date: 12/15/2016 **Req'd Qty:** 1.00

1

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: PE

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

Quality Control

① 16.12.22

JAN 03 2017
DAS
6
9-89

DAS
21
9-89

JAN 06 2017

DAS
21
9-89 JAN 03 2017

Picklist Print

Thursday, December 15, 2016 1:34:02 PM

Page 1
1

Work Order ID: 154600

154600

Parent Item: D3824-1KIV

D3824-1KIV

Parent Item Name: Hat Bin-Ivory

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry material 10/04/21 DL

Ipp Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3-62015		Purchased	No			100	sf	1,381.229	11.41	11.41571			DAS 07 9-89

MKYD6185S 125-P3-62015

Kydex Ivory (52"x96"-125)

16/12/21

Location	Loc Qty	Loc Code
SHED	797	
m129548	347	
m130382	450	
therm	584.22947	
110426	584.22947	

11,425g ft.

DART AEROSPACE LTD		Work Order:	154600
Description: Hat Bin		Part Number:	D3824-1KIV/KGY
Inspection Dwg: D3824 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS 07 9-89

Date: 16/12/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+0.05/-0.00	0.437"	✓			
48.5	Ref	48.5"	✓			
34.1	Ref	34.0"	✓			
41.6	Ref	41.6"	✓			
3.5	Ref	3.5"	✓			
0.055	Min	0.105"	✓			

Measured by: DAS 07 9-89

Date: 16/12/22

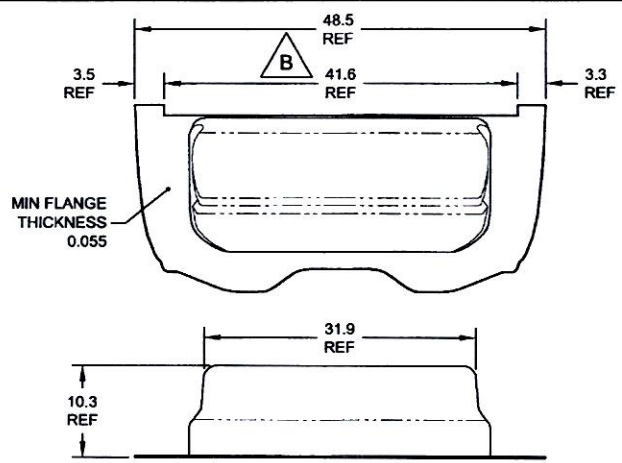
Audited by: 9 9-89

Date: 16-12-22

Prototype Approval: N/A

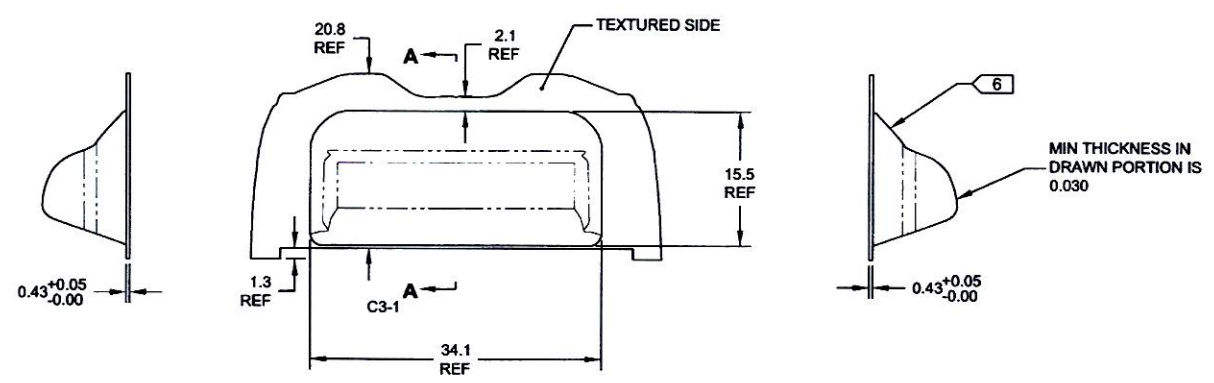
Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ [Signature]	[Signature]



SECTION A-A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154600 *HL5*
16-12-15



D3824-1 HAT BIN
(BELL 206 A/B)

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 5.6 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3824-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY; MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2)	PH	09.02.19
A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3824
REV. C
SHEET 1 OF 2
TITLE HAT BIN (BELL 206 A/B)
SCALE NTS
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